Work Order ID 69068

Wednesday, April 27, 2011 2:39:44 PM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 4/27/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/13/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-04-27 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2221	Revision Nbr: Rev H								
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: 115528 ***PLEASE NOTE*** IF MAKING -041A OR -043A : DRILL HOLES FOR GAS SPRING IN D3825-041 AS PER DSI 9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00							

11.05.04

11.05.04

1 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA; N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69068

Wednesday, April 27, 2011 2:39:45 PM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 4/27/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/13/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69068

Wednesday, April 27, 2011 2:39:45 PM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 4/27/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/13/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QS1005 4.3-Steel	0.00				1X			
Powdercoat	**Memo**	0.00							
Powder Coating	1- Plug holes prior to								
M 116964	1ST COAT: START TIME: 4:00 OVEN TEMPERATURE: 400 oF FINISH TIME: 4:30								
	********** 2nd coat if necessary **********								
	2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
						M.L 11/05/04			
140	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control						1 of 1 ll 11/05/05			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69068

Wednesday, April 27, 2011 2:39:45 PM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 4/27/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/13/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: C-A w/o 69067	0.00							
Packaging	**Memo**	0.00							
Packaging							11/05/05		
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control							11/5/05 MF 11-05-05		

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 2:39:41 PM

Work Order ID: 69068

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 4/27/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:J 05.09.02 Added D3442-1 □KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	22.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				WA006		22							
					67350	10							
					67465	12							
D2221-5 Rib		Manufactured	No			100	Each	8.0000	2	2			
				Location		**Loc Qty**		**Loc Code**					
				WA006		8							
					67399	8							
D2221-7 Rib		Manufactured	No			100	Each	7.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				WA006		7							
					65854	3							
					67274	4							

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 2:39:42 PM

Work Order ID: 69068

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 4/27/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2232-3	Manufactured	No		100	Each	4.0000	2	2

Basket Hinge

Location	Loc Qty	Loc Code
WA005	4	
66894	4	

D2235-1	Manufactured	No		100	Each	12.0000	2	2

Basket Rib

Location	Loc Qty	Loc Code
WA005	12	
66086	2	
66895	10	

D2581	Manufactured	No		100	Each	16.0000	2	2

Mounting Bracket

Location	Loc Qty	Loc Code
WA005	16	
66806	16	

D3442-1	Manufactured	No		100	Each	17.0000	2	2

Shim

Location	Loc Qty	Loc Code
WA005	17	
64271	2	
65783	15	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 2:39:42 PM

Work Order ID: 69068

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 4/27/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3825-041	Manufactured	No		100	Each	6.0000	2	2

Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA	6	
67476	6	

D3826-041	Manufactured	No		100	Each	0.0000	2	2

Rib / Gusset Assembly

D3827-041	Manufactured	No		100	Each	9.0000	1	1

Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA006	9	
65485	3	
67275	6	

D3832-1	Manufactured	No		100	Each	5.0000	1	1

Mesh (Base)

Location	Loc Qty	Loc Code
WA	5	
67034	2	
67477	3	

D3833-1	Manufactured	No		100	Each	19.0000	2	2

Mesh (Base End Face)

Location	Loc Qty	Loc Code
WA	19	
64246	2	
65937	8	
67459	9	

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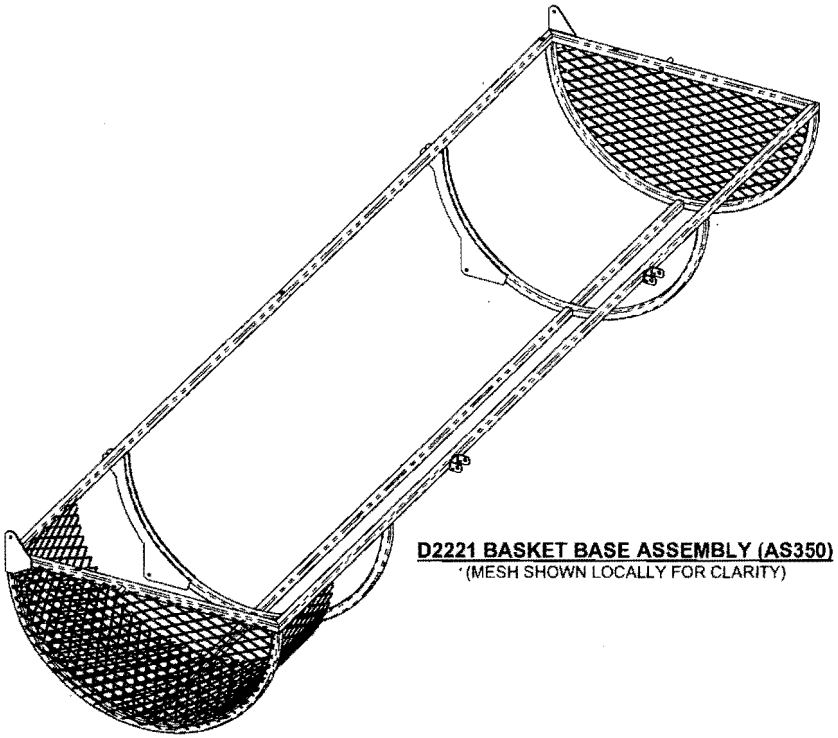
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	**BASKET BASE ASSEMBLY (AS350)**
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISED 08/11/18

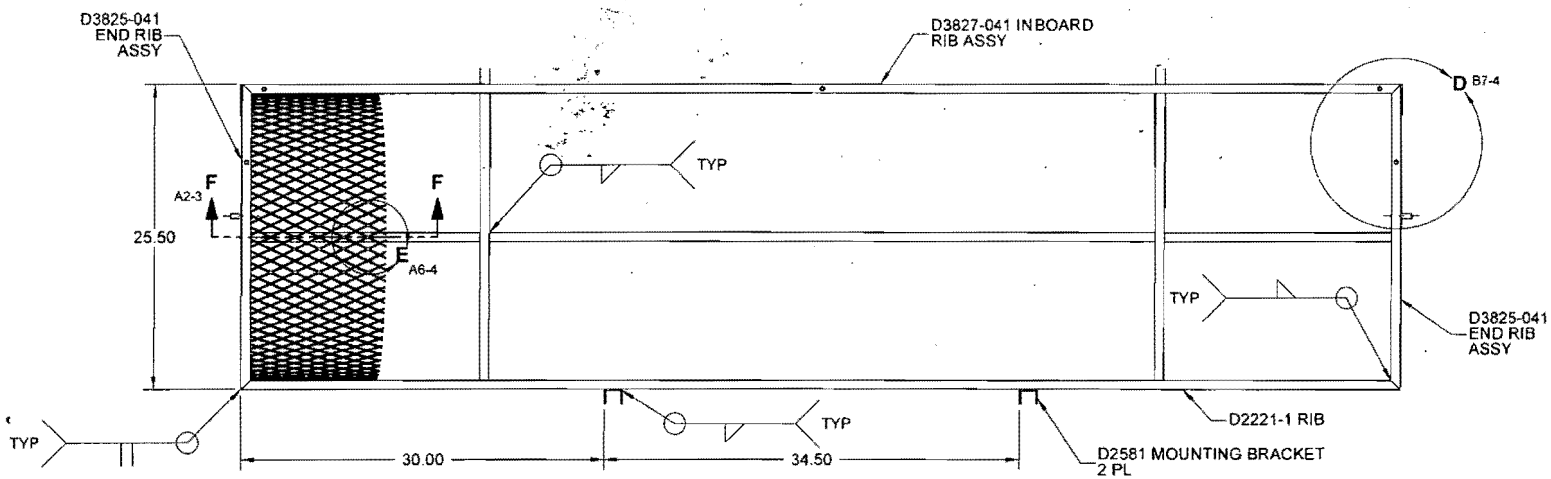
REV.	DESCRIPTION	BY	DATE
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.050 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21

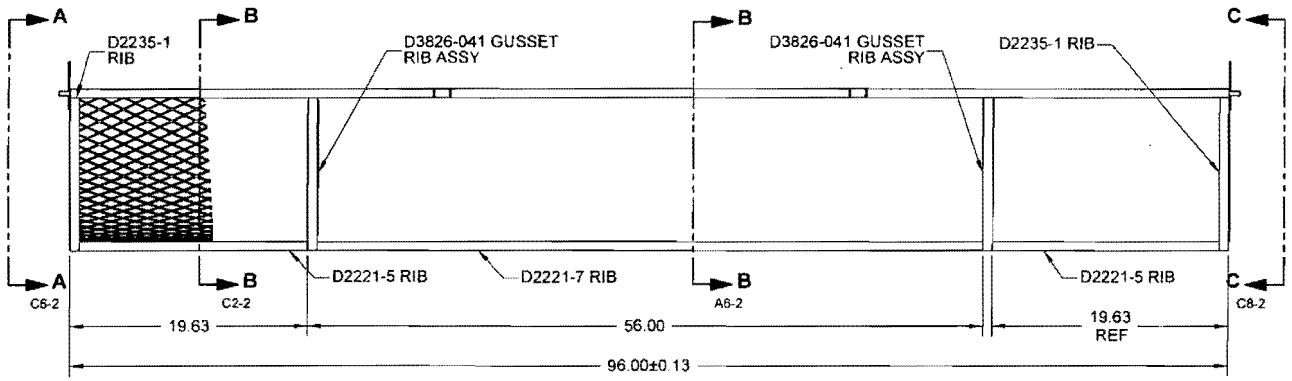
#69066

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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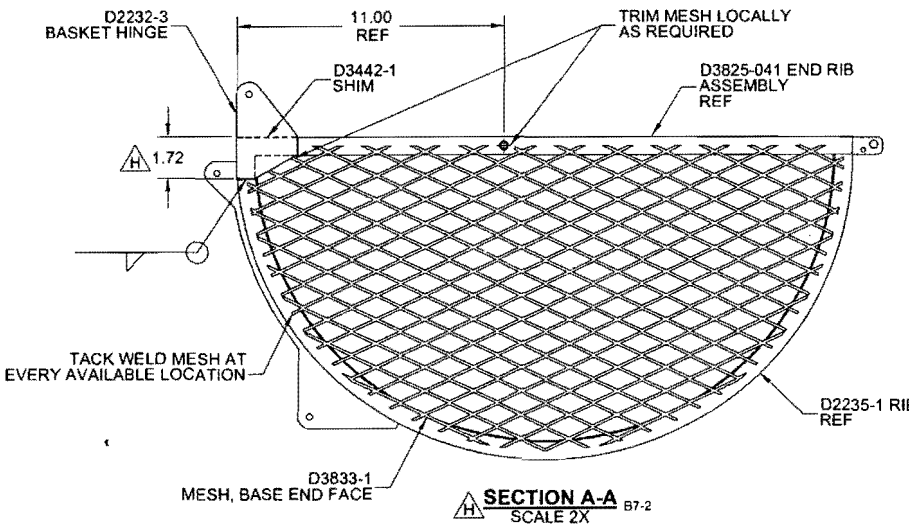
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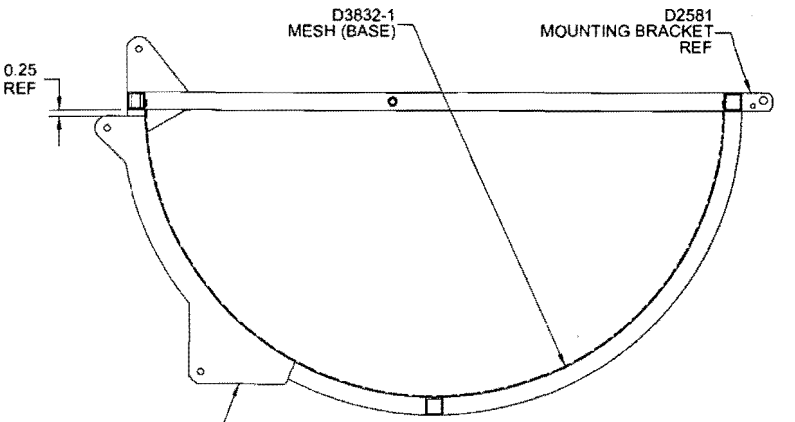
D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE 08.09.18		

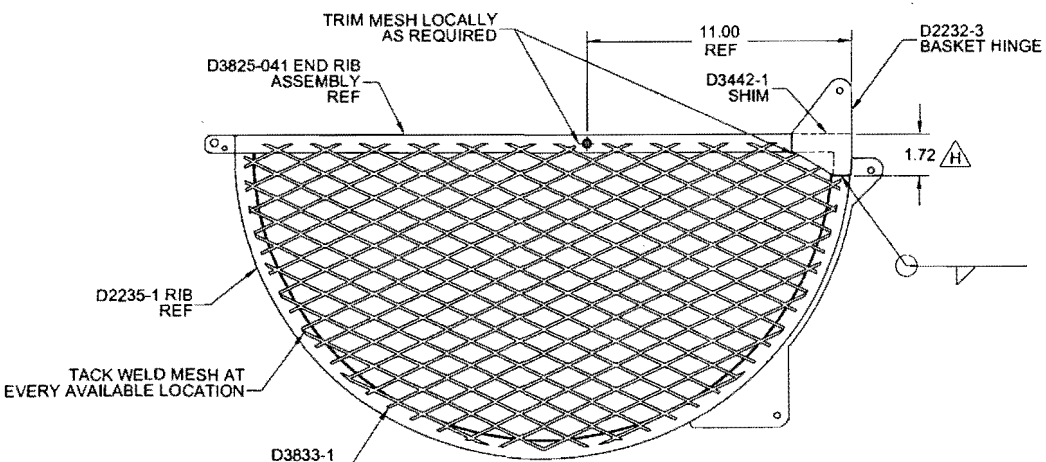
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H **SECTION A-A** B7-2
SCALE 2X



H **SECTION B-B** B6-2 B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)
SCALE 2X



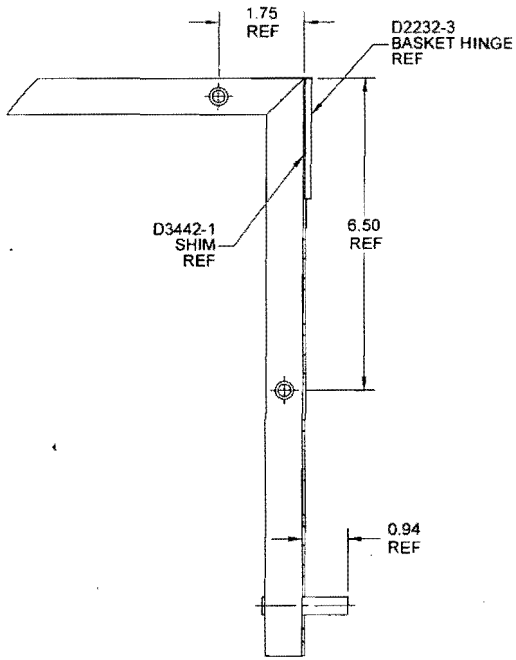
H **SECTION C-C** B2-2
SCALE 2X

#69068

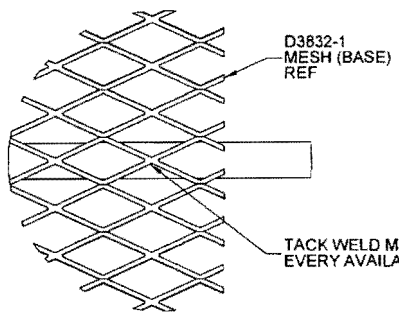
RELEASED
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DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H SHEET 3 OF 5
MFG. APPR.		
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

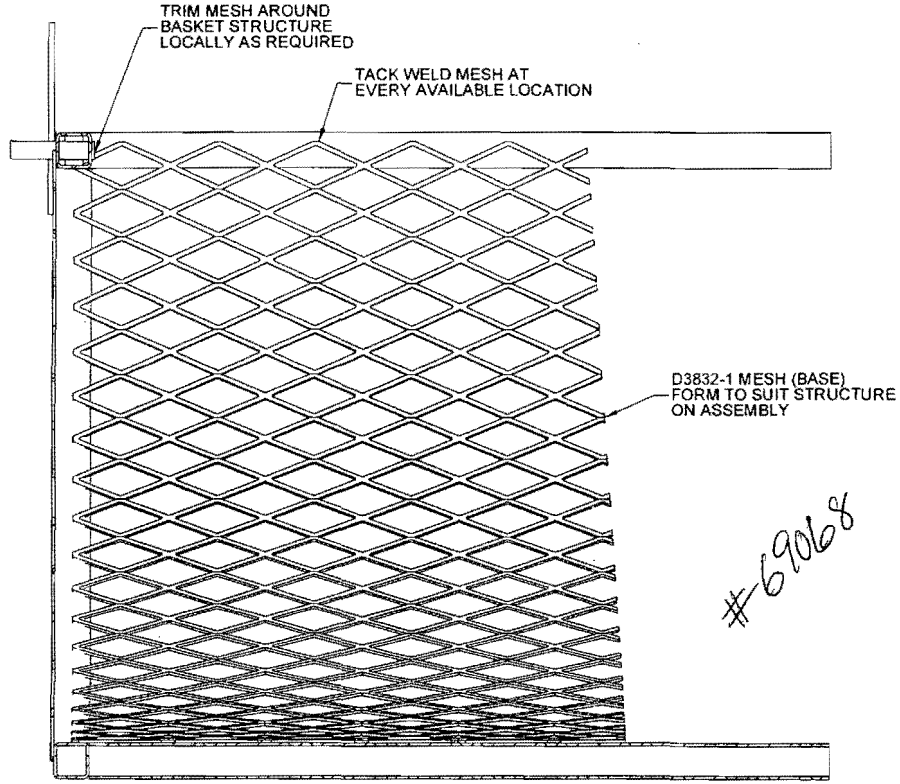
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H DETAIL D SCALE 4X D2-2



H DETAIL E SCALE 4X C6-2



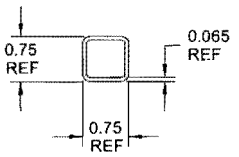
H SECTION F-F SCALE 4X D7-2

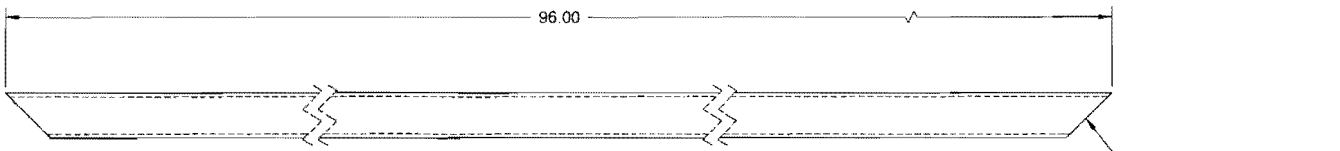
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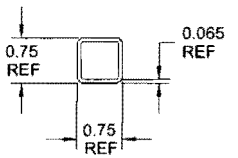
DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D2221 SHEET 4 OF 5
APPROVED		TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS
DATE	08.09.18	

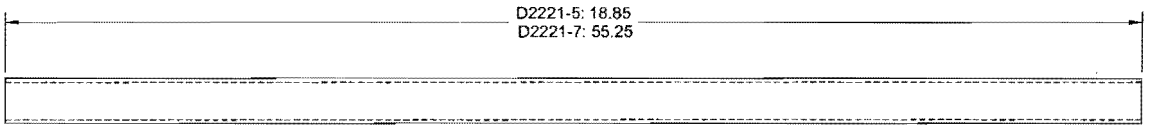
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(H) D2221-1 RIB





(H) D2221-5/-7 RIB

#69068

RELEASED 08/11/18 JW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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